

# Work Order ID 63289

Wednesday, October 27, 2010 10:17:54 AM



Page 1

Item ID: D212-725-1-221F

Accept



Setup Start



Revision ID:

Stop



Item Name: Gusset

Start Date: 10/27/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 10-10-27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D212-725-1	E

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

304.000

1-Cut as per Dwg

Dwg Rev: E

Prog Rev: E

2-Deburr if necessary

B 10-10-29

5

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-10-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 63289**

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Item ID: D212-725-1-221F

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Revision ID:

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Item Name: Gusset

Start Date: 10/27/2010 Start Qty: 2.00

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Required Date: 11/30/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC8- Inspect parts - second check

0.00

0.00

S 10/10/29

(2)

QC

Memo

Quality Control

130

Bend as per dwg

0.00

0.00

S 10/11/07

(2)

Brake NC

Memo

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00

0.00

S 10/11/09

(2)

QC

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D212-725-1-221F

Accept

Setup Start

Revision ID:

Stop

Item Name: Gusset

Start Date: 10/27/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Identify as per dwg & Stock Location: 387

0.00



Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

C. 10/11/01 @10/11/01C. 10/11/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, October 27, 2010 10:17:57 AM

Page 1

Work Order ID: 63289



Parent Item: D212-725-1-221F



Parent Item Name: Gusset



Start Date: 10/27/2010

Required Date: 11/30/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 10.07.21 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S25GA 		Purchased	No			100	sf	19.1900	0.114	0.24			
304/316 .020" Sheet												10-10-09	

Location

Loc Qty

Loc Code

MAT20

19.19

107436

16.19

107513

3

107436

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



0512-725-1-221F

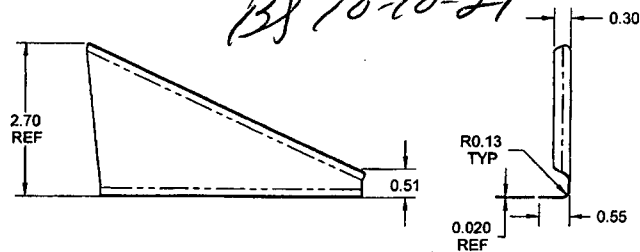
<input checked="" type="checkbox"/>	First Article	<input checked="" type="checkbox"/>	Prototype
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Measured by: <b>MB</b>	Audited by: <b>S</b>	Prototype Approval:
Date: <b>10-10-29</b>	Date: <b>10/10/29</b>	Date:

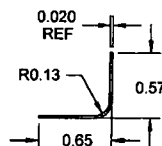
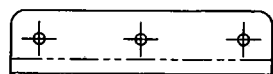
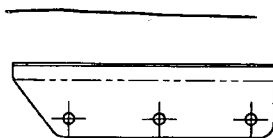
H:\FORMS\Quality Assurance\approved QA\FAI revD

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

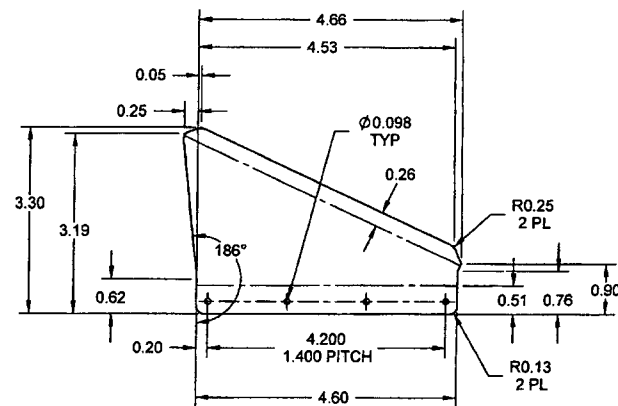
WITHOUT NOTICE  
WORK ORDER  
NO. 63289  
Bf 10-10-27



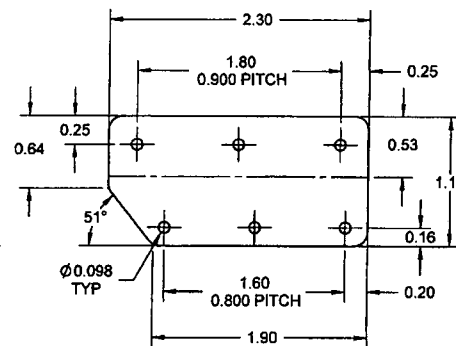
**D212-725-1-221 GUSSET**  
(MAKE FROM D212-725-1-221F FLAT PATTERN)  
SCALE 0.5X



**D212-725-1-223 ANGLE**  
(MAKE FROM D212-725-1-223F FLAT PATTERN)



**D212-725-1-221F FLAT PATTERN**  
(SCALE 0.5X)



**D212-725-1-223F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316/321 ANN STAINLESS STEEL 0.020 (25 GAUGE) SHEET PER AMS-5513/-5524/-5510
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DS	DRAWING NO.	REV. E
MFG. APPR.	N/A	<b>D212-725-1</b>	SHEET 78 OF 82
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>212S DETAIL PARTS</b>	NTS
DATE	08.09.17	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED  
2009-10-28  
*[Signature]*

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